

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001377**Date Inspected:** 03-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 715**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1715**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Xu Xian Ping	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes No N/A	
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes No N/A	
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes No N/A	
Approved Drawings:	Yes No N/A	Approved WPS:	Yes No N/A	
		Delayed / Cancelled:	Yes No N/A	
Bridge No:	34-0006	Component:	OBG and Tower Mock-up	

Summary of Items Observed:

CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the fabrication scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

Bay I (OBG Deck)

The QA inspector observed that ZPMC was performing milling operations at the edges of the U-ribs plates, drilling holes with the bush hardened template at the ends of the U-ribs and bending the U-ribs to their final shape.

Bay II (Tower Mock-up)

The QA inspector observed that ZPMC was performing grinding operations on the weld reinforcement at the junction of loose diaphragm plate to the diaphragm SA-95 on the Tower Mock-up 77 M and laying out control and assembly lines before ZPMC start the assembling and drilling of the interior splices plates on the Tower splice Mock-up 114.

ZPMC was performing cutting operations for the fabrication of the Tower diaphragms, plate # p964-1, p433 for the 13 M and 9 M Tower elevation.

Bay III (OBG Side Plate Welding)

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The QA inspector observed ZPMC performing welding operations at the junction of the side plate SP60 with the WT stiffeners; weld joints SP-060-013 thru 024 with Gantry machine using the flux core arc welding process (FCAW) in the horizontal (2F) position. Certified welding Inspector Xu Xian Ping was observed at this location performing welding parameters verifications. The QA inspector performed random visual inspections of the 6 mm fillet weld after the welding was completed. The QA inspector observed minor weld repairs needed to be completed.

Tower Shop (Tower Mock-up 89 M), Bays VII and VIII

The QA inspector did not observe any fabrication activities on these bays.

Summary of Conversations:

The QA inspector had a conversation with the ZPMC QC inspector Li Li Ming. The QA inspector requested to ZPMC to confirm a class A rejectable indication at the junction of the skins A and B at the Tower splice Mock-up 114 M upper shaft at approximately Y location 330 mm from the upper end. ZPMC QC inspector Xue Hai Rong verified the indication and concurred with the QA inspector assessment.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Acuna,Alfredo	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
